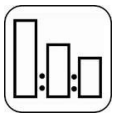
Description

High quality acrylic urethane 2K System which provides a high film build combined with excellent gloss and hiding. It is designed to have an excellent durability and chemical resistance. This product can be easily tinted with nax Superio tinting system.

Suitable Substrates

Existing finishes with the exception of thermoplastic acrylic finishes
All nax Superio / n–Power / nax Pro EZ - primers, primer fillers / surfacers.



2	n-Power 2K Premixed White/Black
1	n-Power 215 hardener
10 – 20%	nax Thinners

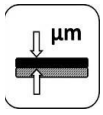


Spray-gun setup:
Gravity fed | 1.3-1.4 mm

Application Pressure:
1.7-2.2 bar | 28-30 psi | At spray-gun air inlet
HVLP max 0.6-0.7 bar (8-10 psi) at the air cap



2-3 coats



20-30 µm /coat



Between coats:
6 - 8 minutes at | 20°C | 70°F

Before 60°C (140°F) baking:
15 -20 minutes at | 20°C | 70°F



	20°C (70°F)	30°C (86°F)	40°C (100°F)	60°C (140°F)	Infra-Red
Dust dry	20-25 min.	15-20 min.	10-15 min.	-	n/a
Dry to handle	6 hrs.	5 hrs.	4 hrs.	40 minutes	5+10 minutes
Dry to polish	12 hrs.	10 hrs.	8 hrs.	30 min after cooldown	5+10 minutes



n-Power 2K Premixed White/Black	2 years
n-Power 215 hardener	4 years
nax Thinners	4 years



The VOC content of this product in ready to use form is maximum 640 g/liter



Use suitable respiratory protection

Nippon Paint Automotive Refinishes recommends the use of fresh air supply respirator.

For detailed information read entire TDS

Product and Additives

Product	n-Power 2K Premixed White/Black	Acrylic polyol resin	
Hardener	n-Power 215 hardener	Poly-isocyanate resin	
Thinners	nax 10 Fast Thinner	Blend of solvents	5-20°C
	nax 20 Medium Thinner	Blend of solvents	20-35°C
	nax 30 Slow Thinner	Blend of solvents	35-45°C
	nax 40 Extra Slow Thinner	Blend of solvents	35-50°C
Additives	nax Softener		

Final surface preparation



- Finishing dry sanding steps: P400
- Initial dry sanding step may be executed with a coarser grit: P320
- For spot repair, finish the blending area with:



- Finishing wet sanding steps: P800
- Initial dry sanding step may be executed with a coarser grit: P320
- Initial wet sanding step may be executed with a coarser grit: P600
- For spot repair, finish the blending area with: P1000



- Prior to SB topcoat application degrease the surface using nax solvent borne degreaser.
- Use clean quality rags or wiping towels, one for wetting and one for drying.
- Apply sufficient degreaser to keep the surface wet and wipe degreaser off before it can evaporate

Notes: *Respect 100 grit maximum jump in dry sanding steps and 200 grit maximum jump in wet sanding steps. For detailed surface preparation see TDS*

Flexible Parts

Type of Plastic	Flexible	Soft	
n-Power 2K Premixed White/Black	100	100	By volume
nax Softener	5	10	By volume

Notes: *Hard plastic requires no softener.*
For plastic type information check nax Softener TDS (naxAR.08.012)
Stir well after adding the additive

Mixing



Mixing Machine

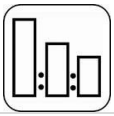
Stir toners on mixing machine twice a day for 15 minutes and just before formula mixing.



Color Mix

Must be stirred thoroughly directly after mixing the formula.

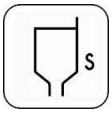
Mixing



2	n-Power 2K Premixed White/Black
1	n-Power 215 hardener
10-20%	nax Thinners

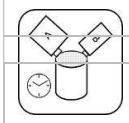
Notes: *Stir after each added component*

Viscosity (DIN 4 Cup)



Application	20°C(70°F)	30°C(86°F)
Standard	15-18 sec	14-16 sec
Flexible	15-18 sec	14-16 sec

Pot Life



Application	20°C(70°F)	30°C(86°F)	40°C(100°F)
▸ 20% thinner	6 Hrs.	4 Hrs.	2 Hrs.

Spray gun set-up / application pressure



Spray-gun type	Spray-gun type	Nozzle size		Application pressure
▸ LVLP	Gravity	1.3-1.4	mm	1.7-2.2 bar at the spray gun air inlet
▸ HVLP	Gravity	1.3-1.4	mm	(HVLP: max 0.6-0.7 bar at the air cap)

Application



- Apply one medium coat, then allow to flash for 6-8 minutes.
- Apply the 2nd and if required a 3rd wet coats allowing 6-8 minutes between coats.

Notes: *Flash-off time depends on ambient temperature, applied layer thickness and airflow.*

Drying time



Dust dry	20°C(70°F)	30°C(86°F)	40°C(100°F)	60°C(140°F)	Infra-Red
▸ Standard	20-25 min.	15-20 min.	10-55 min.	n/a	n/a
▸ Flexible	30-25 min.	25-30 min.	20-25 min.	n/a	n/a
Dry to handle					
▸ Standard	6 hrs.	5 hrs.	4 hrs.	40 min.	5+10 min.
▸ Flexible	9 hrs.	7 hrs,	5 hrs.	50 min.	5+10 min.
Dry to polish					
▸ Standard	12 hrs.	10 hrs.	8 hrs.	30 Min after cool down	
▸ Flexible	14 hrs.	12 hrs.	1 hrs.		

Notes:
Indicated drying times are panel temperatures. Oven temperature should be set 10 °C higher.
Allow 10 minutes flash off prior to Infra-Red drying.
The panel must not reach a temperature above 100°C (210°F) while curing.
Following the drying cycle at 60°C (140°F) object temperature, allow product to completely cool down to ambient temperature.
Using fast hardener at high temperatures can decrease the gloss.

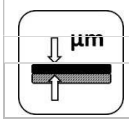
Polishing



Dust and minor imperfections can be polished out after the indicated air-dry times, or after a one hour cool down time following the full bake at 60°C object temperature. Carefully sand out dust particles and restore the surface according to polishing recommendations.

Notes:

Film thickness



Application		
▸ Standard	Using the recommended application technique	20-30 µm / coat
▸ Flexible	Using the recommended application technique	20-30 µm / coat

Coverage

By using the recommended application, the theoretical material coverage is:

- ±7 m²/liter RTS mixture at 45 µm

Notes: *The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.*

Equipment cleaning

Solvent borne gun cleaners

Shelf life & Storage



n- Power 2K Premixed White/Black		2 years	
n-Power 215 hardener		4 years	
nax Thinners		4 years	
Minimum storage temperature:	5°C (41°F)	Maximum storage temperature:	35°C (95°F)

Notes: *Product shelf-life is determined when products are stored unopened at 20°C (70°F).Avoid extreme temperature fluctuation.*

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It is always the responsibility of the recipient of our products to ensure that any proprietary rights, existing laws, legislation are observed and to take all necessary steps to fulfill the demands set out in the local rules and legislation. The latest version of TDS supersedes all previous versions.

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